

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018380**Date Inspected:** 26-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Visual Inspection Testing (VT) on lift-4 tower shafts for fit-lug plate cut-outs

This QA inspector performed VT on lift-4 tower shafts for fit-lug plate cut-outs at 119 M elevation on North, East, West and South shafts. It has been observed that ZPMC personnel have completed the repair work as per the TC-RFI-ZPM-0166R0 on North shaft. The member is identified as TOWER Component.

For further details please see the below attached pictures:

Fit-up of Façade assembly on lift-4 tower shafts at 119 M elevation

This QA inspector observed fit-up of façade assembly on lift-4 tower shafts at 119 M elevation. Fit-up has been carried out between east, south and west shafts. The member is identified as TOWER Component.

For further details please see the below attached pictures:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

BAY#10

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 014 located on Bike Path BK004A5 – 029. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 110 located on Bike Path BK004A5 – 029. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Shielded Metal Arc Welding (SMAW):

Weld joint # 131 located on Bike Path BK004A5 – 029. Welder is identified as 040268. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2213 – B – U2.

Weld joint # 112 located on Bike Path BK004A5 – 029. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2213 – B – U2.

BAY#11

This QA Inspector observed the following work in progress

Sub-merged Arc Welding (SAW):

Weld joint # 23A located on Lift-6 Tower Head component WSD1 – FFSA6 – 4. Welder is identified as 040699. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – U3c – S – 2.

Fluxcored Arc Welding (FCAW):

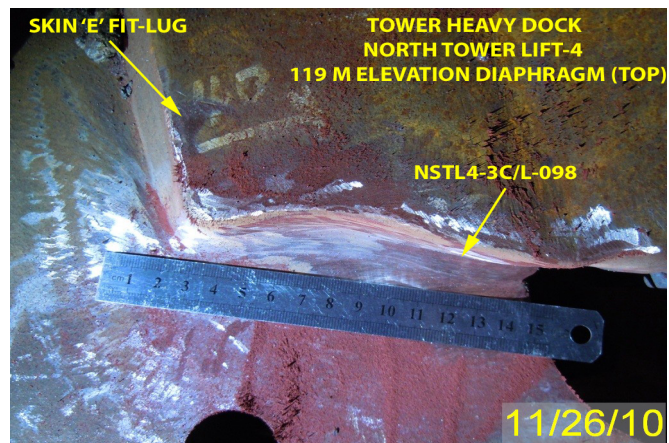
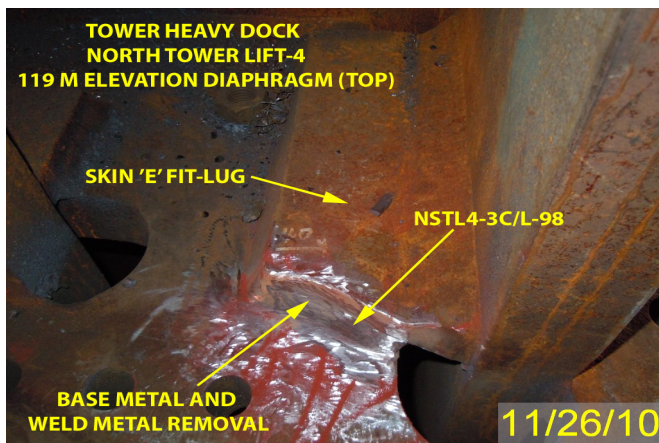
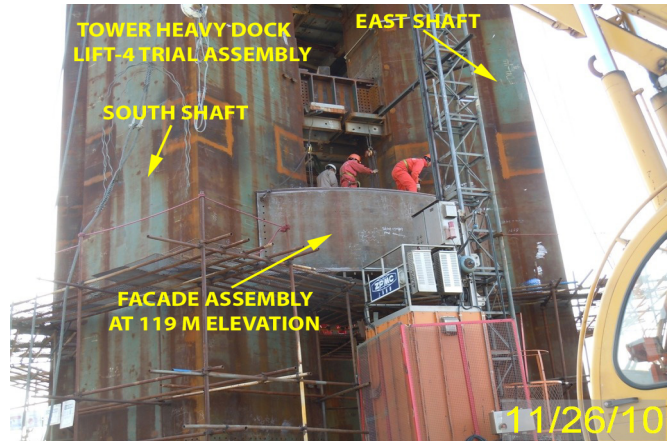
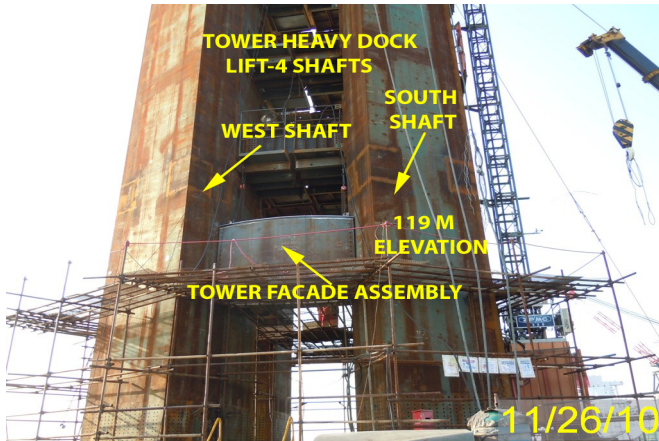
Weld joint # 08 located on Lift-6 Tower Head WSD1 – FDSA6 – 4. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 05 located on Lift-6 Tower Head component WSD1 – FFSA6 – 4. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U3c – F – 2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Reviewed By: Clifford,William

Quality Assurance Inspector

QA Reviewer